

**Work Order ID 51527**

August 25, 2009 1:35:19 PM



Page 1

Item ID: D2594-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Plug, 205 Skidtube

100  
JH

Start Date: 8/28/09 Start Qty: 1,006.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 1,006.00



Customer:

**Reference:**

Approvals: Process Plan:

Date: 08-25 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description****Set Up/  
Run Hours****Draw  
Number****Draw  
Rev.****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

Draw Nbr	Revision Nbr
D2594	Rev C

100



Hardinge CNC LATHE SMALL

0.00

Hardinge

**Memo**

0.00

Hardinge CNC Lathe Small

I-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max.

100

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

**Memo**

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

**Memo**

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 51527

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Item ID: D2594-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Plug, 205 Skidtube

Start Date: 8/28/09 Start Qty: 1,006.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 1,006.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

130



HandFinish

Hand Finishing

Operation  
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/  
Run Hours

0.00

→ 41

Draw  
Number

09/09/02

Draw  
Rev.

Plan  
Code

100

Accept  
Qty

100

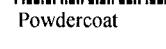
Reject  
Qty

0

Reject  
Number

Insp.  
Stamp

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

→ 41 09/09/03

100

0

Memo

11/26/09

0.00

Memo

7:00PM

START TIME: 7:00PM OVEN TEMPERATURE:

7:30AM FINISH TIME:

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

→ 41 09-09-3

100

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 51527**

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Item ID: D2594-1

Revision ID: C

Item Name: Plug, 205 Skidtube

Start Date: 8/28/09 Start Qty: 1,006.00

Required Date: 9/18/09 Req'd Qty: 1,006.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

160



Packaging

Packaging

Operation  
DescriptionIdentify as per dwg & Stock Location: FP-ASet Up/  
Run Hours

0.00

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

9/09/09 09/09/03 (090903)

09/09/03  
09-09-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

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Work Order ID: 51527



Parent Item: D2594-1RevC

Parent Item Name: Plug, 205 Skidtube

Start Date: 8/28/09

Required Date: 9/18/09

Comments:

Start Qty: 1,006.00

Required Qty: 1,006.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased	No			110	f	83.8100	55.1712			

6061-T6 Round Bar .625"



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

MAT	83.81	
109733	5.72	
110250	18.09	
111650	60	

54843 DJR 09/09/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	51527
Description: Plug, 2055 Kitube	Part Number:	D2594-1
Inspection Dwg:	Rev: C	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article Prototype

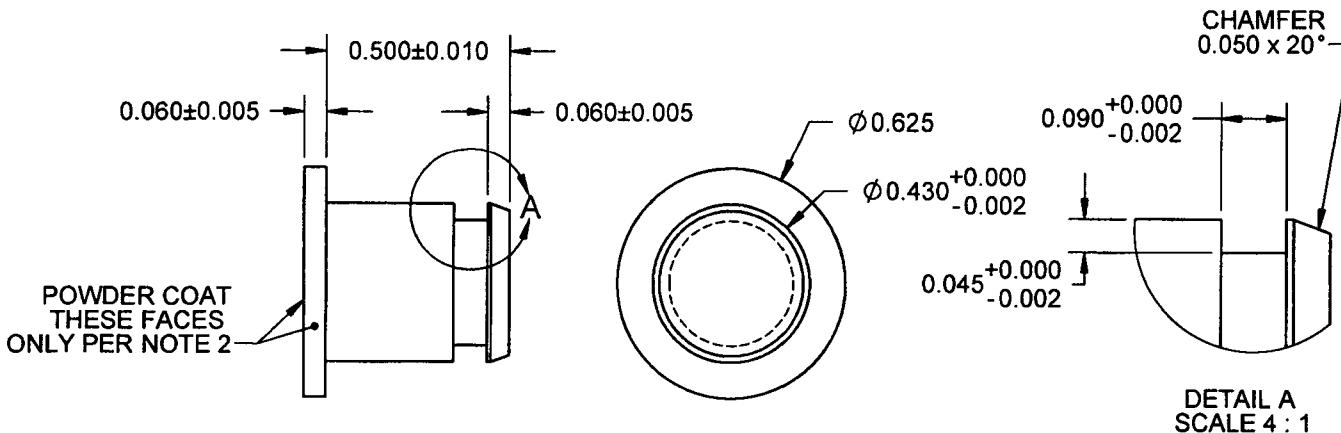
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/09/01	Date:	09-09-02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

**DART**

DESIGN <i>AA</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. <b>D2594</b>	REV. C	SHEET 1 OF 1
DATE <b>06.11.20</b>		TITLE <b>PLUG</b>	SCALE	2:1
REV	DATE	DESCRIPTION		
A	96.09.16	NEW ISSUE		
B	97.03.15	ADD GROOVE AND O-RING		
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE		

REPLACES D2594-1  
06.11.28

**D2594-1 PLUG****D2594-1 PLUG NOTES:**

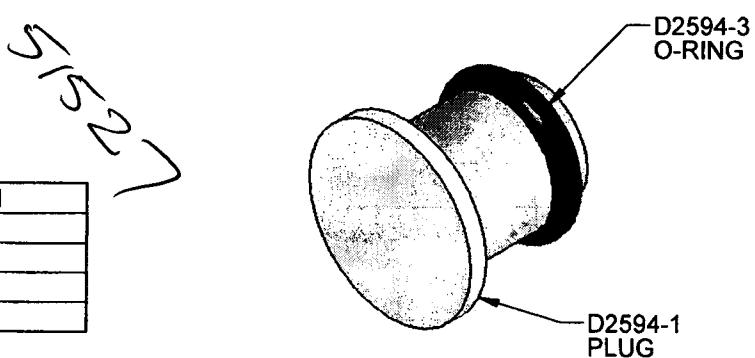
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

**D2594-3 O-RING NOTES:**

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

**PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

**D2594 PLUG ASSEMBLY**

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